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TRANSMITTAL LETTER TO THE UNITED STATES
DESIGNATED/ELECTED OFFICE (DO/EO/US)
CONCERNING A FILING UNDER 35 U.S.C. 371

4197-107

U.S. APPLICATION NO. (If known, see 37 CFR 1.5)

09/936086

INTERNATIONAL APPLICATION NO.

PCT/DE00/00552

INTERNATIONAL FILING DATE

24 February 2000

PRIORITY DATE CLAIMED

8 March 1999

TITLE OF INVENTION

METHOD FOR PRODUCING SHAPED BODIES

APPLICANT(S) FOR DO/EO/US

Thomas Schulze, Eberhard Taeger and Dieter Vorbach

Applicant herewith submits to the United States Designated/Elected Office (DO/EO/US) the following items and other information:

1. ☒ This is a **FIRST** submission of items concerning a filing under 35 U.S.C. 371.
2. ☐ This is a **SECOND** or **SUBSEQUENT** submission of items concerning a filing under 35 U.S.C. 371.
3. ☐ This express request to begin national examination procedures (35 U.S.C. 371(f)) at any time rather than delay examination until the expiration of the applicable time limit set in 35 U.S.C. 371(b) and PCT Articles 22 and 39(1).
4. ☒ A proper Demand for International Preliminary Examination was made by the 19th month from the earliest claimed priority date.
5. ☒ A copy of the International Application as filed (35 U.S.C. 371(c)(2))
 - a. ☒ is transmitted herewith (required only if not transmitted by the International Bureau).
 - b. ☒ has been transmitted by the International Bureau.
 - c. ☐ is not required, as the application was filed in the United States Receiving Office (RO/US).
6. ☒ A translation of the International Application into English (35 U.S.C. 371(c)(2)).
7. ☐ Amendments to the claims of the International Application under PCT Article 19 (35 U.S.C. 371(c)(3))
 - a. ☐ are transmitted herewith (required only if not transmitted by the International Bureau).
 - b. ☐ have been transmitted by the International Bureau.
 - c. ☐ have not been made; however, the time limit for making such amendments has NOT expired.
 - d. ☐ have not been made and will not be made.
8. ☐ A translation of the amendments to the claims under PCT Article 19 (35 U.S.C. 371(c)(3)).
9. ☒ An oath or declaration of the inventor(s) (35 U.S.C. 371(c)(4)).*(**Unsigned**)
10. ☒ A translation of the annexes to the International Preliminary Examination Report under PCT Article 36 (35 U.S.C. 371(c)(5)).

Items 11. to 16. below concern other document(s) or information included:

11. ☐ An Information Disclosure Statement under 37 CFR 1.97 and 1.98.
12. ☐ An assignment document for recording. A separate cover sheet in compliance with 37 CFR 3.28 and 3.31 is included.
13. ☒ A FIRST preliminary amendment.
☐ A SECOND or SUBSEQUENT preliminary amendment.
14. ☐ A substitute specification.
15. ☒ A small entity statement.
16. ☐ Other items or information: International Search Report

NOTE: This application is being filed with an unsigned Oath or Declaration under the provisions of 37 CFR § 1.53 in order that applicants may secure a filing date of July 13, 2001. Upon receipt of a "Notice to File Missing Parts - Filing Date Granted," a Declaration and Power of Attorney, and an Assignment in favor of applicants' assignees, Chronos Holdings Ltd. will be filed in the Patent and Trademark Office. The undersigned agent affirmatively states that she has been duly authorized and appointed to file this application on behalf of the applicants and applicants' assignees, and that the Declaration and Power of Attorney to be filed hereafter will confirm the undersigned agent's authorization and appointment. Applicants and Ostthuringische Materialprufgesellschaft Fur Textil und Kunststoffe MBH are entitled to small entity status within the meaning of 37 CFR § 1.9.

518 Rec'd PCT/PTO 05 SEP 2001

- 17.
- ☒
- The following fees are submitted:

Basic National Fee (37 CFR 1.492(a)(1)-(5)):

Search Report has been prepared by the EPO or JPO\$860.00

International preliminary examination fee paid to USPTO (37 CFR 1.482)\$0.00

No International preliminary examination fee paid to USPTO (37 CFR 1.482) but international search fee paid to USPTO (37 CFR 1.445(a)(2))\$0.00

Neither international preliminary examination fee (37 CFR 1.482) nor international search fee (37 CFR 1.445(a)(2)) paid to USPTO\$1000.00

International preliminary examination fee paid to USPTO (37 CFR 1.482) and all claims satisfied provisions of PCT Article 33(2)-(4)\$0.00

ENTER APPROPRIATE BASIC FEE AMOUNT =

\$ 860.00

Surcharge of **\$130.00** for furnishing the oath or declaration later than ☐ 20 ☐ 30 months from the earliest claimed priority date (37 CFR 1.492(e)).

\$

Claims

Number Filed

Number Extra

Rate

Total Claims

14-20 =

0

X \$18.00

\$

Independent Claims

1-3 =

0

X \$80.00

\$

Multiple dependent claim(s) (if applicable)

+ \$270.00

\$

TOTAL OF ABOVE CALCULATIONS =

860.00

Reduction by 1/2 for filing by small entity, if applicable. Verified Small Entity statement must also be filed. (Note 37 CFR 1.9, 1.27, 1.28).

\$ 430.00

SUBTOTAL =

\$ 430.00

Processing fee of **\$130.00** for furnishing the English translation later than ☐ 20 ☐ 30 Months from the earliest claimed priority date (37 CFR 1.492(f)).

\$

TOTAL NATIONAL FEE =

\$ 430.00

Fee for recording the enclosed assignment (37 CFR 1.21(h)). The assignment must be accompanied by an appropriate cover sheet (37 CFR 3.28, 3.31). \$40.00 per property

\$

TOTAL FEE ENCLOSED =

\$ 430.00

Amount to be:
refunded

\$

Charged

\$

- a. ☒ A check in the amount of \$430.00 to cover the above fees is enclosed.
- b. ☐ Please charge my Deposit Account No. _____ in the amount of \$ _____ to cover the above fees.
A duplicate copy of this sheet is enclosed.
- c. ☒ The Commissioner is hereby authorized to charge any additional fees which may be required, or credit any overpayment to Deposit Account No. 08-3284. A duplicate copy of this sheet is enclosed.

NOTE: Where an appropriate time limit under 37 CFR 1.494 or 1.495 has not yet been met, a petition to revive (37 CFR 1.127(a) or (b)) must be filed and granted to restore the application to pending status.

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23448

PATENT TRADEMARK OFFICE

4197-107

PATENT APPLICATION

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

In re Application of: Thomas Schulze, et al.

Application No.: New U.S. National Stage Application of
PCT International Application No.
PCT/DE00/00552

International Filing Date: 24 February 2000

Priority Date Claimed: 08 March 1999 (German Appl. No. 199 10 012.8)

U.S. National Phase Filing Date: Date of mailing identified below

Title: **METHOD FOR PRODUCING SHAPED
BODIES**

EXPRESS MAIL CERTIFICATE

I hereby certify that I am mailing the attached documents to the
Commissioner for Patents on the date specified, in an envelope
addressed to the Commissioner for Patents, Box Patent Application,
Washington, DC 20231, and Express Mailed under the provisions of
37 CFR 1.10

Blake Crouch

Name of Person Mailing This Document


Signature

September 5, 2001

Date

EL666414049US

Express Mail Label Number

PRELIMINARY AMENDMENT

Commissioner for Patents
BOX PATENT APPLICATION
Washington, D.C. 20231

Sir:

Prior to examination of the above-identified new national phase patent application, please amend the application, as follows:

In the Claims

1. (Amended) A procedure for the manufacture of molded parts, in particular threads or films, the procedure comprising:

forming at least two polymer solutions comprising at least one polymer in a solvent containing amine-N-oxide wherein the at least one polymer is selected from the group consisting of polysaccharide, polysaccharide derivative and polyvinyl alcohol; and

simultaneously extruding the at least two polymer solutions to form a combined extrudate and precipitating the extrudate by bringing it into contact with a coagulant, wherein at least one of the polymer solutions contains at least one additive selected from the group consisting of oxides, carbides, borides, nitrides, oxynitrides, siolones and aluminosilicates, carbon-containing materials, metal powders, metal salts, polymer fibers, particle suspensions, inorganic or organic, ceramic-forming low or high-molecular compounds, the additive having a functional ability selected from the group consisting of catalytically active, electronically or ionically conductive, piezoelectric, insulating, pore-forming, mechanically strengthening, absorbing or surface active, and wherein the polymer solutions have a weight ratio of polymer to additive of 10:1 to 1:100.
2. (Amended) The procedure according to claim 1, wherein at least two polymer solutions differ in at least one property selected from the group consisting of particle size, material composition and content of additives.
3. (Amended) The procedure according to claim, wherein the additives have a particle size ranging from 0.01 to 1000 μm .
4. (Amended) The procedure according to claim 1, wherein the polymer solutions are extruded at different volumetric rates.

5. (Amended) The procedure according to claim 1, wherein the two or more polymer solutions are concentrically extruded and, to form massive bi- or multi-component threads, coagulated only from outside.
6. (Amended) The procedure according to claim 1, wherein the two or more polymer solutions are concentrically extruded and, to form massive three-component threads, an additive dispersion is centrally supplied and coagulated from outside.
7. (Amended) The procedure according to claim 1, wherein the volumetric ratio between the two or more extruded polymer solutions and a centrally supplied space-filling liquid or a gas is selected in such a way as to expand the polymer solution hose.
8. (Amended) The procedure according to claim 1, wherein the two or more polymer solutions are concentrically extruded and, to form bi- or multi-component threads, coagulated from inside and outside.
9. (Amended) The procedure according to claim 1, wherein the extrudate is stretched in an air gap before precipitation to set the dimensions of the core and jacket layers.
10. (Amended) The procedure according to claim 1, wherein the coagulated extrudate is dried, and its polymer content is removed and/or carbonized via thermal treatment.
11. (Amended) The procedure according to claim 10, wherein the thermal treatment is conducted in a temperature range of 250 to 3500 °C in the presence of oxygen, inert gas or under a vacuum.
12. (Amended) The procedure according to claim 10, wherein the thermal treatment takes place in a first stage at a lower temperature, and in a second stage at a higher temperature, and that oxidizing conditions prevail only in one of the two stages.
13. (Amended) The procedure according to claim 1, wherein monohydrate of the N-oxide-N-oxide is used as the solvent.


14. (Amended) The procedure according to claim 1, wherein cellulose is used as the polymer.

REMARKS

A marked-up version of amended claims 1-14 is included herewith in Appendix A.

It is requested that the examination and prosecution of this application proceed on the basis of the English translation of the PCT International application included herewith and these amended claims 1-14

Respectfully submitted,



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APPENDIX A

Please amend claims 1-14 as follows:

1. (Amended) A procedure for the manufacture of molded parts, in particular threads or films, the procedure comprising:

forming at least two polymer solutions comprising at least one polymer in a solvent containing amine-N-oxide wherein the [out of] at least one polymer is selected from the group consisting of [comprised of] polysaccharide, polysaccharide derivative and polyvinyl alcohol; and [by forming an additive-containing solution of the polymer in a solvent containing amine-N-oxide,]

simultaneously extruding the at least two polymer solutions to form a combined extrudate [solution] and precipitating the extrudate by bringing it into contact with a coagulant, wherein at least [two polymer solutions are formed, of which at least] one of the polymer solutions contains at least one [or more] additive[s], [and the at least two polymer solutions are simultaneously extruded accompanied by the formation of a combined extrudate, characterized by the fact that use is made of the additives is] selected from the group consisting of oxides, carbides, borides, nitrides, oxynitrides, siolones and aluminosilicates, carbon-containing materials, metal powders, metal salts, polymer fibers, particle suspensions, inorganic or organic, ceramic-forming low or high-molecular compounds, [and] the additive having a functional ability selected from the group consisting of catalytically active, electronically or ionically conductive, piezoelectric, insulating, pore-forming, mechanically strengthening, absorbing or surface active, and wherein the polymer solutions have [with] a weight ratio of polymer to additive of 10:1 to 1:100. [are used, and wherein the additives are catalytically active, electronically or ionically conductive, piezoelectric, insulating, pore-forming, mechanically strengthening, absorbing or surface active.]

2. (Amended) The procedure according to claim 1, [characterized by the fact that the] wherein at least two polymer solutions differ in at least one property selected from the group consisting of [terms of the] particle size, [and/or] material composition and[/or] content of additives.

3. (Amended) The procedure according to claim 1 [or 2, characterized by the fact that], wherein the additives have [with] a particle size ranging from 0.01 to 1000 μ m[, preferably from 0.05 to 100 μ m, are used].
4. (Amended) The procedure according to claim 1, [one of claims 1 to 3, characterized by the fact that] wherein the polymer solutions are extruded at different volumetric rates.
5. (Amended) The procedure according to claim 1, [one of claims 1 to 4, characterized by the fact that] wherein the two or more polymer solutions are concentrically extruded and, to form massive bi- or multi-component threads, coagulated only from outside.
6. (Amended) The procedure according to claim 1, [one of claims 1 to 4, characterized by the fact that] wherein the two or more polymer solutions are concentrically extruded and, to form massive three-component threads, an additive dispersion is centrally supplied and coagulated from outside.
7. (Amended) The procedure according to claim 1, [one of claims 1 to 4, characterized by the fact that] wherein the volumetric ratio between the two or more extruded polymer solutions and a centrally supplied space-filling liquid or a gas is selected in such a way as to expand the polymer solution hose.
8. (Amended) The procedure according to claim 1, [one of claims 1 to 7, characterized by the fact that] wherein the two or more polymer solutions are concentrically extruded and, to form bi- or multi-component threads, coagulated from inside and outside.
9. (Amended) The procedure according to claim 1, [one of claims 1 to 8, characterized by the fact that] wherein the extrudate is stretched in an air gap before precipitation to set the dimensions of the core and jacket layers.
10. (Amended) The procedure according to claim 1, [one of claims 1 to 9, characterized by the fact that] wherein the coagulated extrudate is dried, and its polymer content is removed and/or carbonized via thermal treatment.

11. (Amended) The procedure according to claim 10, wherein [characterized by the fact that] the thermal treatment is conducted in a temperature range of 250 to 3500 °C in the presence of oxygen, inert gas or under a vacuum.
12. (Amended) The procedure according to claim 10, [or 11, characterized by the fact that] wherein the thermal treatment takes place in a first stage at a lower temperature, and in a second stage at a higher temperature, and that oxidizing conditions prevail only in one of the two stages.
13. (Amended) The procedure according to claim 1, [one of claims 1 to 12, characterized by the fact that the] wherein monohydrate of the N-oxide-N-oxide is used as the solvent.
14. (Amended) The procedure according to claim 1, wherein [one of claims 1 to 13, characterized by the fact that] cellulose is used as the polymer.

PROCEDURE FOR THE MANUFACTURE OF MOLDED PARTS

The invention relates to a procedure for the manufacture of molded parts, such as threads or films, out of at least one polymer from the group comprised of polysaccharide, polysaccharide derivative and polyvinyl alcohol by forming a solution of the polymer in a solvent containing amine-N-oxide, extruding the solution and precipitating the extrudate by bringing it into contact with a coagulation bath. In particular, the invention relates to a procedure for manufacturing multi-layer, massive or hollow filaments, fibers or films.

It is known that powdery and liquid additives can induce targeted changes in the properties of polymers. Admixing function-imparting substances to polymer melts or solutions yields numerous special polymeric substances. In this case, it must be remembered that powdery or liquid additives can influence the flow behavior of polymer melts or solutions in such a way as to create significant problems in the manufacturing process. The suitability of a potential additive as a function-imparting agent is also determined by its solubility and reactivity relative to the polymers, solvents and aids used in the manufacturing process, as well as to the temperature and processing/preparation conditions during the manufacture of the solution and subsequent treatment of the products. Another problem when processing several polymers or polymer solutions at once involves adjusting pure with modified polymer phases, or of several differently modified polymer phases.

In conventional polymer wet spinning procedures, these problems always become evident when large quantities of additives are admixed in a finely dispersed manner, and the obtained solutions are to be processed via spinning. In particular, highly acidic and alkaline working conditions of the kind necessary for dissolving and regenerating the

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cellulose greatly limit the number of possible additives. In addition, it is known that larger quantities of additives can result in a loss of spinability, e.g., due to viscosity changes in both melt spinning processes and conventional wet spinning procedures.

While these disadvantages are circumvented by using the Lyocell procedure (DE 44 26 966 A1), the procedure in the described form does not enable the manufacture of multiple-layer, functional threads.

The object of the invention is to create a procedure which can be used to manufacture massive or hollow multi-component molded parts, e.g., fibers, filaments and films, with greatly varying charges of identical or different additives. In particular, a procedure for manufacturing molded parts with symmetrical core jacket structures or asymmetrical structures is to be provided. Preferably to be provided is an extrusion procedure for manufacturing multi-component molded parts, which have a variety of uses, and in particular yield materials with special properties and use properties. Other advantages stem from the following description.

This object is achieved in the procedure mentioned at the outset according to the invention by generating at least two polymer solutions, of which at least one contains one or more solid or liquid, finely dispersed additives, and by simultaneously extruding the at least two polymer solutions accompanied by the formation of a combined extrudate. It was surprisingly found that an extrudate forms according to the invention in which two or more polymer solutions are mutually integrated and combined in such a way that no separation of the layers formed by the various polymer solutions takes place either during precipitation or subsequent drying and possible thermal treatment. This also holds true when the additives in the polymer solutions vary

greatly in terms of their particle size, material composition and content. Depending on the used additives, the molded part present after precipitation can have the most varied of uses. The procedure can start out from various polymer solutions, e.g., two polymer solutions, of which only one has a solid or liquid additive, two polymer solutions, which both contain solid or liquid additives, three polymer solutions, whose additives differ by type, particle size and/or content, etc. The used solutions can contain 1 to 20 %w/w, preferably 4 to 16 %w/w, of the polymer. In particular polyols, such as cellulose, starch or polyvinyl alcohol, and their derivatives, can be used as the polymers. The additives are added 1) either at the outset of solution manufacture to the polymer-solvent-water mixture, 2) after prior complete dissolution of the polymers, or 3) into the polymer-solvent mixture, and finely dispersed therein through vigorous mixing or kneading. In all cases, the polymers dissolve during the evaporation of a production-related excess of water under a vacuum at elevated temperatures. The massive or hollow multi-component molded parts manufactured according to the invention can have special functional properties owing to the incorporated additives, e.g., electronic or ionic conductivity, as well as magnetic or catalytic activity.

According to the preferred embodiment of the procedure, the at least two polymer solutions are distinguished by the particle size and/or the material composition and/or the content of additives. The procedure provides a way to control the thickness and function of the layers by loading the polymer solution(s) with additive. Loading the polymer solution(s) to varying levels results in different shrinkages, and hence to adjustable layer thicknesses; different additives in the polymer solutions can impart various functions to the molded parts.

The solid additives are preferably set with a particle size ranging from 0.01 to 1000 μm , in particular from 0.05 to 100 μm . The additives can be inorganic or organic, or mixtures of both substances.

In the preferred embodiment of the procedure according to the invention, use is made of additives from the group consisting of oxides, carbides, borides, nitrides, oxynitrides, silones and aluminosilicates. In addition, use can be made of carbon-containing materials, metal powders, metal salts, polymer fibers, particle suspensions, ceramic-forming low or high-molecular compounds, sinterable inorganic compounds, lead zirconium titanates or mica in a finely dispersed suspension.

In the procedure according to the invention, use can be made of polymer solutions with a weight ratio of polymer to additive of 10:1 to 1:100. The share of polymer to additive preferably ranges from 1:1 to 1:7. The weight ratio of polymer to additive often ranges from 9:1 to 1:10.

The polymer solution is preferably extruded at varying volumetric rates (e.g., by setting the displacement of the conveyor pumps). In this way, the layer formation on the molded parts can be controlled in such a way that both thick, preferably 100 to 200 μm thick layers and thin, 0.1 to 20 μm thick layers can be formed. If only a polymer solution loaded slightly with additives (weight ratio of additive to polymer = 0.5 to 2.0) is extruded together with a higher loaded solution (weight ratio of additive to polymer = 5 to 8) in roughly the same volume shares per unit of time, a thin cover layer on a thicker hollow structure results after preparation and drying, which is important for the manufacture of ceramic hollow membranes or carriers of functional components.

In another embodiment of the procedure according to the invention, the volumetric ratio between the two or more concentrically extruded polymer solutions and a centrally supplied coagulant or gas is selected in such a way as to expand the polymer solution tube or composite tube. Setting the quantity of centrally supplied coagulant, space-filling liquid or gas yields the desired level of expansion. The liquid polymer solutions are already pre-stabilized on the inside by contact with the coagulant. The hollow filaments manufactured in this way can have a diameter ranging from 0.1 to 5 mm in a freshly spun state. Coagulation can take place with air, water, organic solvents or particle dispersions. The use of such solvents for hollow-space formation, which do not instantly result in the coagulation of cellulose, makes it possible to fabricate hollow filaments with low diameters (compare Example 10). If internal coagulation by adding space-filling liquids is not

performed, the liquid spinning jets underneath the nozzle can combine immediately without the formation of continuous or blistered hollow spaces, and hence form a massive core-jacket structure. Two or more solutions are best extruded concentrically and coagulated to form bi- or multi-component hollow threads from inside and outside, or only from outside. The hollow threads are characterized by inner radius R_1 and outer radius R_2 . The invention extends to hollow threads in a range of $0 \leq R_1 < R_2$, i.e., also encompasses massive threads without a hollow space. The extrudate can be stretched in an air gap before precipitation to set the dimensions of the core and jacket layer(s). In this case, the extruded solutions can be passed over an air gap preferably 1 to 500 mm wide, wherein the high spinning safety either produces a delay owing to the force of gravity of the free-falling polymer solution, or stretches the still liquid solution jet as the result of a specific delay. It can also be directly introduced into the precipitation bath for immediate coagulation. The polymer solutions deformed in this way can be introduced into a coagulation bath containing a precipitant, preferably water, for purposes of final stabilization via the instantaneous precipitation of the polymer on the outer layer of the thread before the solvent that still adheres primarily on the inside is removed through continuous or batch-wise treatment with cold or warm water, being replaced entirely by water while retaining the swelling state, and completely precipitating out the carrier polymer matrix.

In the preferred embodiment of the procedure according to the invention, the coagulated extrudate is dried and passed on to a specific application, or its polymer content is removed via thermal treatment. Through the elimination of the polymer matrix, this thermal treatment yields special materials based on the selected additives, e.g., inorganic, porous, multi-layer hollow membranes, multi-layer membrane

reactors, ceramic-matrix composites, conductive multi-component fibers, catalyst carriers and ionic conductors. It was discovered that the multi-layer molded part withstands thermal treatment without impairment, in particular without the layers detaching, separating or developing cracks, even though very different additives are used or great charging differences exist between the polymer layers of the molded part. The procedure according to the invention also makes it possible to set the size and density of the pores in the thermally treated body through the selection of additives. In porous hollow membranes, the porosity and pore size of the layers can be controlled by the parameters of the extrusion procedure or properties of the polymer solutions. Thermal treatment over the stability limit of the polymer, preferably that of the cellulose, makes it possible to convert the multi-component extrudates into purely inorganic, porous or microcrystalline, dense structures. The thermal treatment can also be conducted in such a way that the polymer content is only converted into carbon.

The thermal treatment is preferably conducted at a temperature ranging from 250 to 3500 °C in the presence of oxygen, inert gas or under a vacuum. In this case, the complete or partial pyrolysis/combustion of the matrix polymer yields a purely ceramic, metallic or carbon-containing fiber or a composite with carbon layers.

Thermal treatment best takes place in a first stage at a lower temperature, and in a second stage at a higher temperature, and oxidating conditions prevail in only one of the two stages.

The monohydrate of N-methylmorpholine-N-oxide is preferably used as the solvent for the polymers. Cellulose is preferably used as the polymer, even though other polyols or polysaccharides can be used separately or in mixture. It

has been discovered that solid adhesion between the layers in the precipitated or dried or thermally treated extrudate is achieved even given a very different particle size and/or charging of the polymer solutions with additive and/or pronounced chemical differences in the additives.

Fig. 1 shows the diagrammatic axial section of a three-component circular nozzle for the procedure according to the invention, with a central cylindrical channel and two annular channels 2, 3.

Fig. 2 shows four different fiber cross-sections, which can be manufactured using the procedure according to the invention.

To further illustrate the procedure according to the invention, the manufacture of different multi-layer structures will be explained based on the following examples.

Example 1

Aluminum oxide with an average particle size of $0.7\text{ }\mu\text{m}$ is added to a 7.5 %w/w polysaccharide solution (8 parts cellulose, 2 parts amylose) in N-oxide-N-oxide monohydrate in a percentage by weight of 500 %w/w relative to the cellulose share. In like manner, a solution is prepared having aluminum oxide with an average particle size of $3.6\text{ }\mu\text{m}$ in the same proportions. Both solutions are extruded at a temperature of approx. $100\text{ }^{\circ}\text{C}$ through a double-slit hollow core nozzle in a ratio of 1:1, wherein the same volumetric percentage of water is pumped through the inside of the nozzle to achieve hollow structures. The nozzle was situated a distance of 10 cm away from the aqueous precipitation bath. The bi-component hollow filaments spun in this way without any additional pull-off were repeatedly extracted with warm water and then dried at room

temperature under a constant load. The resulting materials had a outside diameter of approx. 1 mm. Drying was followed by sintering at 1500 °C. The layers that formed in the process exhibited pore sizes of 950 and 150 nm. (Fig. 2D).

Example 2

Aluminum oxide with an average particle size of 0.7 μm is added to a 7.5 %w/w cellulose solution in N-oxide-N-oxide monohydrate in a percentage by weight of 250 %w/w relative to the cellulose share. In like manner, a solution is prepared having an aluminum oxide with an average particle size of 1.2 μm relative to the cellulose share of 500 %w/w. Both solutions are co-extruded at a temperature of approx. 90 °C at a ratio of core to jacket of 3 : 1, and relayed to a water bath vertically over a 15 cm long air gap. During extrusion, a quantity of water corresponding to the volume flux of both pumps is pumped inside the nozzle. The raw filaments spun in this way are stripped of solvent through repeated extraction with warm water, and dried at room temperature for several hours. After sintering at 1450 °C, pore sizes of 450 or 200 nm result for the core and jacket layer. (Fig. 2D).

Example 3

Aluminum oxide with an average particle size of 0.7 μm is added to a 9 %w/w cellulose solution in N-oxide-N-oxide monohydrate in a percentage by weight of 700 %w/w relative to the cellulose share. This solution is extruded together with a 9 %w/w pure polysaccharide solution (amylose : cellulose = 1 : 1) in N-oxide-N-oxide monohydrate at 105 °C at a ratio of core to jacket of 1 : 1 through a double-slit nozzle into a monofilament thread, wherein the uncharged solution is passed through the central borehole. The pull-off rate measured 25 m/min. The nozzle was situated a distance of 3 cm away from the aqueous precipitation bath.

The exiting thread was passed through a precipitation bath 2 m long and then wound. After the thread is dried at room temperature, sintering takes place at 1450 °C, and a hollow structure is formed by complete pyrolysis of the cellulose inside the bi-component filament, wherein the remaining jacket layer exhibits an average pore size of 150 nm. (Fig. 2A).

Example 4

A 6.5 %w/w solution of 5 parts cellulose and 1 part carboxymethyl starch in N-oxide-N-oxide monohydrate, which is loaded with 600 %w/w aluminum oxide with an average particle size of 4.6 μm relative to the cellulose share, is extruded together with an uncharged 12 %w/w cellulose solution in a ratio of 1 : 2, wherein the charged solution is metered through the central supply system, and the distance between the nozzle and precipitation bath measures 15 cm. Water is pumped inside the nozzle to generate a hollow structure.

After extraction with water, drying takes place at room temperature. Sintering takes place under an inert atmosphere at 1900 °C with the formation of a porous carbon layer on a carrying ceramic layer. (Fig. 2D).

Example 5

Aluminum oxide with an average particle size of 0.7 μm is added to a 7.5 %w/w cellulose solution in N-oxide-N-oxide monohydrate in a percentage of weight of 500 %w/w relative to the cellulose share. In like manner, a 7.5 %w/w cellulose solution is prepared, which contains silicon carbide with an average particle size of 0.8 μm in a percentage by weight of 500 %w/w relative to the cellulose share. Both solutions are extruded at a ratio of core to jacket of 1 : 1 through a double-slit nozzle into a

monofilament thread, wherein the aluminum oxide-containing solution is passed through the central borehole. The pull-off rate measured 20 m/min. The nozzle was situated a distance of 5 cm away from the aqueous precipitation bath. The exiting thread was passed through a precipitation bath 2 m long, wound and dried at room temperature. Microcrystalline fibers with an aluminum core and silicon carbide jacket were obtained after sintering at 1800 °C in air. (Fig. 2B)

Example 6

Aluminum oxide with an average particle size of 0.7 μm is added to a 6 %w/w solution of cellulose in N-oxide-N-oxide monohydrate in a percentage by weight of 100 %w/w relative to the cellulose share and 1 % nickel powder. This solution is extruded together with a 7.5 %w/w solution of cellulose in N-oxide-N-oxide monohydrate, which is mixed with 500 %w/w aluminum oxide with an average particle size of 4.5 μm relative to the cellulose share, at 85 °C through a double-hollow chamber nozzle at a ratio of 3 : 1, wherein water is pumped inside the nozzle and the distance to the precipitation bath measured 15 cm. Sintering takes place at 1600 °C in an inert atmosphere with subsequent treatment at 500 °C in air. (Fig. 2D)

Example 7

A 9 %w/w solution of cellulose in N-oxide-N-oxide monohydrate is extruded together with a 7.5 %w/w solution of cellulose in N-oxide-N-oxide monohydrate, which contains 100 %w/w soot relative to the cellulose share, at 90 °C in a ratio of 1 : 1 through a double-gap nozzle into a monofilament thread, wherein the pure cellulose solution is supplied through the inner channel. The pull-off rate measured 30 m/min, at a distance between the nozzle and precipitation bath of 2 cm. Passage through an aqueous

precipitation bath was followed by winding, extraction with water and drying at room temperature. (Fig. 2B)

Example 8

A 6.5 %w/w solution of cellulose in N-oxide-N-oxide monohydrate is mixed with 25 %w/w melamine and 75 % boric acid relative to cellulose. This solution is extruded together with a 9 %w/w solution of cellulose in N-oxide-N-oxide monohydrate at 100 °C through a double-slit nozzle, wherein the pure cellulose solution is metered in through the outer slit. The distance to the precipitation bath measured 1 cm, the pull-off rate 12 m/min. Extraction with cold water is followed by drying at room temperature. Thermal treatment took place at 1600 °C, and yielded boron nitride threads through pyrolysis of the polymer and conversion of the filler.

Example 9

A 7 %w/w solution of cellulose in N-oxide-N-oxide monohydrate containing 300 %w/w zirconium oxide relative to the cellulose share is extruded together with a 9 % solution of cellulose in N-oxide-N-oxide monohydrate charged with 100 %w/w nickel powder at 90 °C through a double-slit hollow nozzle, wherein a starch-enriched aqueous metal suspension is pumped through the central supply system, whose composition is set to a ratio of water to starch to metal powder of 30 : 30 : 40. In this case, the solution charged with zirconium oxide is passed through the inner slit of the nozzle, while the solution charged with nickel is passed through the outer slit. At a distance between the nozzle and precipitation bath of 1 cm, 3-component threads are obtained, which are subjected to a drying process at room temperature. After pyrolysis of the polymers, pure 3-component fibers are obtained, which

exhibit a conductor-insulator-conductor layer sequence.
(Fig. 2C)

Example 10

A 9 %w/w solution of cellulose in N-methylmorpholine-N-oxide monohydrate is mixed with aluminum oxide with an average particle size of 0.7 μm , so that the ratio of cellulose to aluminum oxide measures 1 : 3. This solution is extruded at 90 °C through a hollow slit nozzle, wherein ethylene glycol is metered in through the inner channel in such a way that sufficient hollow space formation takes place. The spinning jets are routed into a coagulation bath via an air gap of 5 cm, and pulled off at a rate of 60 m/min. After winding, the adhering solution is removed with water and dried. Thermal treatment at 1600 °C yields hollow fibers with a diameter of 150 μm . (Fig. 2A)

Example 11

A 12 %w/w solution of cellulose in N-oxide-N-oxide monohydrate is extruded together with an 8 %w/w solution of cellulose in N-oxide-N-oxide monohydrate mixed in with 700 %w/w iron powder relative to the cellulose share at 100 °C at a ratio of 1 : 1 through a hollow slit nozzle, wherein the pure solution is supplied through the outer slit. At a distance of 1 cm to the aqueous precipitation bath, the pull-off rate measured 50 m/min. After aqueous extraction and drying, iron powder-filled cellulose filaments are obtained, e.g., of the kind that can be used for shielding purposes.

The polymer solutions are extruded and coagulated according to the Lyocell procedure (H.J. Koslowski, Chemiefaserlexikon, 11th Edition (1998), p. 95, and additional literature). The extrusion temperature for the

polymer solution ranges from 80 to 120 °C, preferably from 85 to 105 °C.

CLAIMS

1. A procedure for the manufacture of molded parts, in particular threads or films, out of at least one polymer from the group comprised of polysaccharide, polysaccharide derivative and polyvinyl alcohol by forming an additive-containing solution of the polymer in a solvent containing amine-N-oxide, extruding the solution and precipitating the extrudate by bringing it into contact with a coagulant, wherein at least two polymer solutions are formed, of which at least one contains one or more additives, and the at least two polymer solutions are simultaneously extruded accompanied by the formation of a combined extrudate, characterized by the fact that use is made of additives from the group consisting of oxides, carbides, borides, nitrides, oxynitrides, siolones and aluminosilicates, carbon-containing materials, metal powders, metal salts, polymer fibers, particle suspensions, inorganic or organic, ceramic-forming low or high-molecular compounds, and wherein polymer solutions with a weight ratio of polymer to additive of 10:1 to 1:100 are used, and wherein the additives are catalytically active, electronically or ionically conductive, piezoelectric, insulating, pore-forming, mechanically strengthening, absorbing or surface active.
2. The procedure according to claim 1, characterized by the fact that the at least two polymer solutions differ in terms of the particle size and/or material composition and/or content of additives.
3. The procedure according to claim 1 or 2, characterized by the fact that additives with a particle size ranging from 0.01 to 1000 μm , preferably from 0.05 to 100 μm , are used.

4. The procedure according to one of claims 1 to 3, characterized by the fact that the polymer solutions are extruded at different volumetric rates.
5. The procedure according to one of claims 1 to 4, characterized by the fact that two or more polymer solutions are concentrically extruded and, to form massive bi- or multi-component threads, coagulated only from outside.
6. The procedure according to one of claims 1 to 4, characterized by the fact that two or more polymer solutions are concentrically extruded and, to form massive three-component threads, an additive dispersion is centrally supplied and coagulated from outside.
7. The procedure according to one of claims 1 to 4, characterized by the fact that the volumetric ratio between the two or more extruded polymer solutions and a centrally supplied space-filling liquid or a gas is selected in such a way as to expand the polymer solution hose.
8. The procedure according to one of claims 1 to 7, characterized by the fact that two or more polymer solutions are concentrically extruded and, to form bi- or multi-component threads, coagulated from inside and outside.
9. The procedure according to one of claims 1 to 8, characterized by the fact that the extrudate is stretched in an air gap before precipitation to set the dimensions of the core and jacket layers.

10. The procedure according to one of claims 1 to 9, characterized by the fact that the coagulated extrudate is dried, and its polymer content is removed and/or carbonized via thermal treatment.
11. The procedure according to claim 10, characterized by the fact that thermal treatment is conducted in a temperature range of 250 to 3500 °C in the presence of oxygen, inert gas or under a vacuum.
12. The procedure according to claim 10 or 11, characterized by the fact that thermal treatment takes place in a first stage at a lower temperature, and in a second stage at a higher temperature, and that oxidizing conditions prevail only in one of the two stages.
13. The procedure according to one of claims 1 to 12, characterized by the fact that the monohydrate of the N-oxide-N-oxide is used as the solvent.
14. The procedure according to one of claims 1 to 13, characterized by the fact that cellulose is used as the polymer.

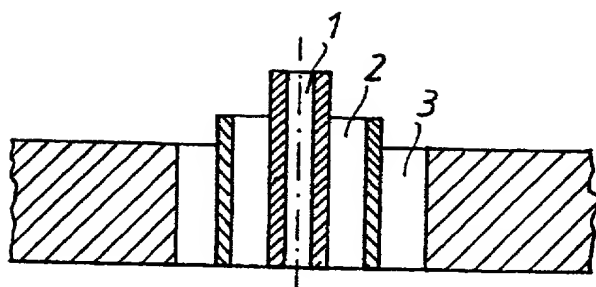


FIG. 1

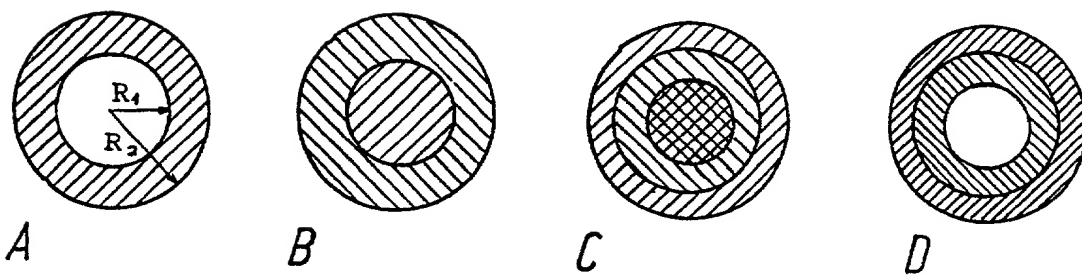


FIG. 2

	1980	1981	1982	1983	1984	1985	1986	1987	1988	1989	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100	2101	2102	2103	2104	2105	2106	2107	2108	2109	2110	2111	2112	2113	2114	2115	2116	2117	2118	2119	2120	2121	2122	2123	2124	2125	2126	2127	2128	2129	2130	2131	2132	2133	2134	2135	2136	2137	2138	2139	2140	2141	2142	2143	2144	2145	2146	2147	2148	2149	2150	2151	2152	2153	2154	2155	2156	2157	2158	2159	2160	2161	2162	2163	2164	2165	2166	2167	2168	2169	2170	2171	2172	2173	2174	2175	2176	2177	2178	2179	2180	2181	2182	2183	2184	2185	2186	2187	2188	2189	2190	2191	2192	2193	2194	2195	2196	2197	2198	2199	2200	2201	2202	2203	2204	2205	2206	2207	2208	2209	2210	2211	2212	2213	2214	2215	2216	2217	2218	2219	2220	2221	2222	2223	2224	2225	2226	2227	2228	2229	2230	2231	2232	2233	2234	2235	2236	2237	2238	2239	2240	2241	2242	2243	2244	2245	2246	2247	2248	2249	2250	2251	2252	2253	2254	2255	2256	2257	2258	2259	2260	2261	2262	2263	2264	2265	2266	2267	2268	2269	2270	2271	2272	2273	2274	2275	2276	2277	2278	2279	2280	2281	2282	2283	2284	2285	2286	2287	2288	2289	2290	2291	2292	2293	2294	2295	2296	2297	2298	2299	2300	2301	2302	2303	2304	2305	2306	2307	2308	2309	2310	2311	2312	2313	2314	2315	2316	2317	2318	2319	2320	2321	2322	2323	2324	2325	2326	2327	2328	2329	2330	2331	2332	2333	2334	2335	2336	2337	2338	2339	2340	2341	2342	2343	2344	2345	2346	2347	2348	2349	2350	2351	2352	2353	2354	2355	2356	2357	2358	2359	2360	2361	2362	2363	2364	2365	2366	2367	2368	2369	2370	2371	2372	2373	2374	2375	2376	2377	2378	2379	2380	2381	2382	2383	2384	2385	2386	2387	2388	2389	2390	2391	2392	2393	2394	2395	2396	2397	2398	2399	2400	2401	2402	2403	2404	2405	2406	2407	2408	2409	2410	2411	2412	2413	2414	2415	2416	2417	2418	2419	2420	2421	2422	2423	2424	2425	2426	2427	2428	2429	2430	2431	2432	2
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PATENT APPLICATION

DECLARATION AND POWER OF ATTORNEY FOR PATENT APPLICATION

ATTORNEY DOCKET NO. 4197-107

As a below named inventor, I hereby declare that:

My residence/post office address and citizenship are as stated below next to my name;

I believe I am the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled:

METHOD FOR PRODUCING SHAPED BODIES

the specification of which is attached hereto unless the following box is checked:

(X) was filed on September 5, 2001 as US Application Serial No. 09/936,086 or PCT International Application

Number _____ and was amended on _____ (if applicable).

I hereby state that I have reviewed and understood the contents of the above-identified specification, including the claims, as amended by any amendment(s) referred to above. I acknowledge the duty to disclose all information which is material to patentability as defined in 37 CFR 1.56.

Foreign Application(s) and/or Claim of Foreign Priority

I hereby claim foreign priority benefits under Title 35, United States Code Section 119(a-d) or 365(b) of any foreign application(s) for patent or inventor(s) certificate, or 365(a) of any PCT international application which designated at least one country other than the United States of America, listed below and have also identified below any foreign application for patent or inventor(s) certificate having a filing date before that of the application on which priority is claimed:

COUNTRY	APPLICATION NUMBER	DATE FILED	PRIORITY CLAIMED UNDER 35 U.S.C 119
Germany	199 10 012.8	08 March 1999	YES <u>X</u> NO <u> </u>
PCT	PCT/DE00/00552	24 February 2000	YES <u>X</u> NO <u> </u>

Provisional Application

I hereby claim the benefit under Title 35, United States Code Section 119(e) of any United States provisional application(s) listed below:

U.S. Priority Claim

I hereby claim the benefit under Title 35, United States Code, Section 120 of any United States application(s) listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in the prior United States application in the manner provided by the first paragraph of Title 35, United States Code Section 112, I acknowledge the duty to disclose material information as defined in Title 37, Code of Federal Regulations, Section 1.56(a) which occurred between the filing date of the prior application and the national or PCT international filing date of this application

APPLICATION SERIAL NUMBER	FILING DATE	STATUS(patented/pending/abandoned)

POWER OF ATTORNEY:

As a named inventor, I hereby appoint the following attorney(s) and/or agent(s) listed below to prosecute this application and transact all business in the Patent and Trademark Office connected therewith.

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I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code and that such willful false statements may jeopardize the validity of the application or any patent issued thereon

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[illegible]